

# Work Order ID 63282

Wednesday, October 27, 2010 9:25:20 AM



Page 1

Item ID:	D212-725-1-161F	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Stiffener Oil Cooler					
Start Date:	10/27/2010	Start Qty:	2.00			
Required Date:	11/30/2010	Req'd Qty:	2.00			
Reference:						

Approvals:	Process Plan:		Date:	10-10-27	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D212-725-1	D								
100		0.00							
Waterjet									
FLOW CNC Waterjet									
2024 .032									
	<b>Memo</b>	0.00							
	1-Cut as per Dwg								
	Dwg Rev:								
	Prog Rev:								
	2-Deburr if necessary								
110		0.00							
QC									
Quality Control									
	<b>Memo</b>	0.00							
	QC2- Inspect parts off machine FAI/FAIB								

AB10-10-28

AB10-10-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63282**

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Page 2

Item ID: D212-725-1-161F

Accept

Setup Start

Revision ID:

Stop

Item Name: Stiffener Oil Cooler

Start Date: 10/27/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 10/10/10

(x2)

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

SS 10/10/10

(2)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/10/10

(x2)

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Item ID: D212-725-1-161F

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Setup Start

Revision ID:

Stop

Item Name: Stiffener Oil Cooler

Start Date: 10/27/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

⇒ 11

10/01/29

2 0



HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

C 10/14/29 (2)

170

Identify as per dwg &amp; Stock Location: 385

0.00



Packaging

Memo

0.00

Packaging

C 10/10/29 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Wednesday, October 27, 2010 9:25:20 AM

Page 4

Item ID: D212-725-1-161F

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Revision ID:

Stop

Item Name: Stiffener Oil Cooler

Start Date: 10/27/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/29 *[Signature]*  
MF  
10-10-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, October 27, 2010 9:25:24 AM

Page 1

Work Order ID: 63282



Parent Item: D212-725-1-161F



Parent Item Name: Stiffener Oil Cooler

Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	72.0000	0.0466	0.098105			



2024-T3 .032 sheet



1810-10-29

Location

Loc Qty

Loc Code

MAT22

72

105555

3

111699

4

113189

65

113189

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

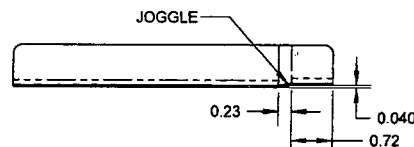
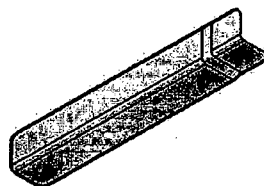
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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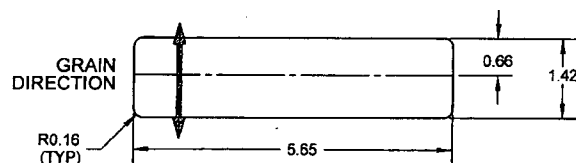
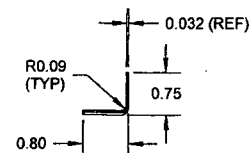
DATA-725-1-161F

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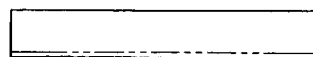
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



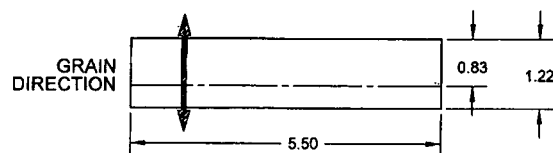
**D212-725-1-159F ANGLE**  
(MAKE FROM D212-725-1-159F)



**D212-725-1-159F FLAT PATTERN**



**D212-725-1-161F STIFFENER**  
(MAKE FROM D212-725-1-161F)



**D212-725-1-161F FLAT PATTERN**

**D212-725-1-159/-161NOTES:**

- 1) MATERIAL: 2024-T3 SHEET 0.032 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.032)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 63282

*2510-10-2*

**RELEASED**  
2009-10-28

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.	N/A	<b>D212-725-1</b>	SHEET 54 OF 67
APPROVED	#	TITLE	SCALE
DE APPR.	#	<b>212S DETAIL PARTS</b>	1:2
DATE	08.03.14	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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